

Date: Tuesday, 4/17/2007 3:55:02 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	31911		
Estimate Number	12801		
P.O. Number	N/A	Part Number	D35377
This Issue	4/17/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3537 UNDER REVIEW
First Issue	N/A	Project Number	N/A
Previous Run	31401	Drawing Revision	A/B C PH 07.04.27
Written By	<u>          </u>	Material	N/A
Checked & Approved By		Due Date	5/10/2007 Qty: 16 Um: Each
Comment	Est Rev:A New Issue 07-03-12 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 
Comment: Qty.: 0.1512 sf(s)/Unit Total : 2.4192 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 1119052		ML 07 05 07  16
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C		ML 07 05 07  16
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		ML 07 05 07  16
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		ML 07 05 08  16
5.0	BRAKE NC	NO BRAKE 
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.		ML 07 05 08  16
SB 07 05 09  16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:55:02 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31911

Part Number: D35377

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

107/05/10 16

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M102956
Weld hardcoat as per Dwg D3437		

FC 07/05/10 16

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/05/10 16

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/05/10 16

10.0 POWDER COATING

POWDER COATING



10101 601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11

04-03-10 16

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Mr. L

07/05/10

12.0 PACKAGING 1

PACKAGING RESOURCE #1



16X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP

16

Mr. L

07/05/10

13.0 QC21

FINAL INSPECTION/W/O RELEASE



16

Comment: FINAL INSPECTION/W/O RELEASE

ND 07/05/11

Job Completion



W 07/05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A'	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31911
Description: Wearpad	Part Number:	D3537-7
Inspection Dwg: D3537	Rev: <del>A/B/C</del> C 07-05-07	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

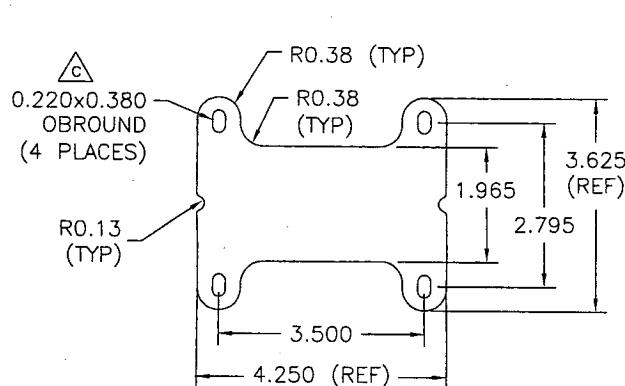
PH  
07.04.27

27

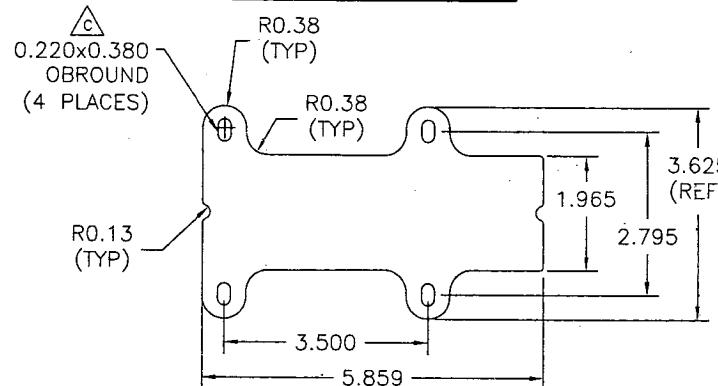
Measured by:	<i>MM MM</i>	Audited by:	<i>MM</i>	Prototype Approval:	N/A
Date:	07/05/07	Date:	07/05/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM 	

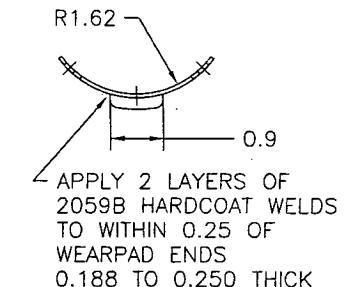
### D3537-1F FLAT PATTERN



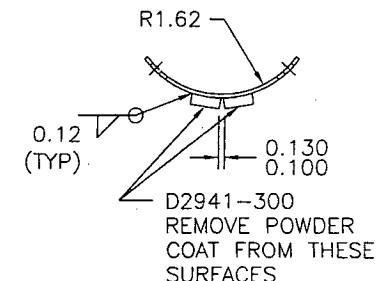
### D3537-3F FLAT PATTERN



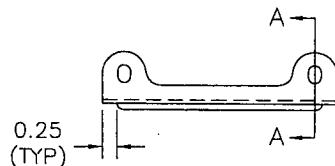
### SECTION A-A



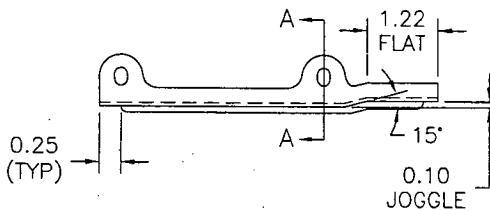
### SECTION B-B



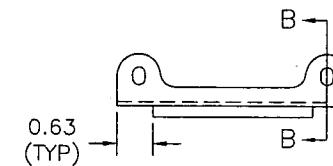
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



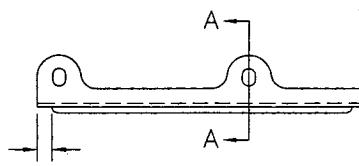
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

PRELIMINARY ISSUE

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DESIGN	07.04.13	WIDEN TAB TO .380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
CHECKED	APPROVED	DART AEROSPACE USA, INC. PORT HADLOCK, WA.
		REV. C D3537 SHEET 1 OF 1
DATE		TITLE WEARPAD SCALE 1:2
07.04.13		